

Work Order ID 76399

76399

Page 1

November-11-11 12:49:29 PM

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 11/11/2011 Start Qty: 1.00 ***1*** Cust Item ID: *****
 Required Date: 25/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:


Approvals: Process Plan: M.L.S Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	HUR Rev I								
100	DOCUMENT CONTROL	0.00							
100		0.00							
DC	Memo								
Document Control	If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG004 CHG 605								

Handwritten: 11/11/11 11/12/11
 11-12-7
 ①

Handwritten: Pro

376399

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.11.15	110	ASSEMBLE PER D3391 Rev.I Tube is CHG LOS	HJ	11/12/06	X1 ASSEMB	 11.11.15 PS1042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O: 76399		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.12.09	100	Acceptable to assemble skid tube with D4095-xxx WEARPLATES PER D3391 Rev. I, which are equivalent to D3564-xxx WEARPLATES, HOWEVER THEY HAVE NO GASKETS D351 9517 Rev. B	CP 11.12.09	CP 11.12.09		CP 11.12.09	

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 76399***76399***

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Item ID: D412-742-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Float Skidtube

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.
A/RSikaflex-241/-291 1119443
Expiry date: 12/05

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 1119443
Expiry date: 12/05

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.
A/RLPS Procyon 1114596

() 12/05

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 Item Name: Replacement Float Skidtube
 Start Date: 11/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: <u>73</u>								
	PPP Rev: <u>SHIP</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

November-11-11 12:49:33 PM

Work Order ID: 76399

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F
 11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			110	Each	2,163.000	24	24			

AN3C4A

BOLT

**

M 11/21/06

Location

Loc Qty

Loc Code

ST350

2163

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

974

119328

1000

824

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

November-11-11 12:49:33 PM

Work Order ID: 76399

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

260.0000

10

10/8

AN3C6A

BOLT

**

11/12/06

PTO 27

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST350

100

119449

100

ST351

159

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

104

10/8

AN3C7A

Purchased

No

110

Each

115.0000

4

4

AN3C7A

BOLT

**

11/12/06

Location

Loc Qty

Loc Code

ST351

115

113149

14

116169

1

117313

10

117619

12

117688

18

118422

60

10/8

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

38

38

***AN960C10I ***

washer

**

11/19/36 (138) 11/12/06

November-11-11 12:49:33 PM

Shop Packet Print

Page 2

W/O: 76399		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/12/06	110	Replace (2x) AN3CGA with (2x) AN3C-5A / M118451	JL	11/12/06	X2	CP 11.12.06. PS/042	So 11/12/06

Part No: D 412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-11-11 12:49:33 PM

Work Order ID: 76399

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3391-021 Manufactured No

110 Each 0.0000 1 1

D3391-021

**

B75935 (x1) M 11/12/06

Fwd Tube Assembly

D3391-023 Manufactured No

110 Each 0.0000 1 1

D3391-023

**

B76392 (x1) M 11/12/06

Mid Tube Assembly

D3391-025 Manufactured No

110 Each 2.0000 1 1

D3391-025

**

B76455 (x1) M 11/12/06

Aft Tube Assembly

Location

Loc Qty

Loc Code

FP

2

73013

1

73014

1

~~D3564-5~~ D4095-045 Manufactured No

110 Each 22.0000 1 1

D3564-5

**

B76536 (x1) M 11/12/06

Wearshoe

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

12

74543

12

FP19

8

73330

8

~~D3566-5~~ D4095-045 Manufactured No

110 Each 30.0000 1 1

D3566-5

**

Gasket

Location

Loc Qty

Loc Code

FP002

30

74387

8

75069

22

W/O:		WORK ORDER CHANGES					
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Work Order ID: 76399

76399

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4095-041

Manufactured No

110

Each

0.0000

1

1

D4095-041

Wearplate Assembly

B76047 (x1) M 11/12/06

D4095-043

Manufactured No

110

Each

0.0000

1

1

D4095-043

Wearplate Assembly

B76048 (x1) M 11/12/06

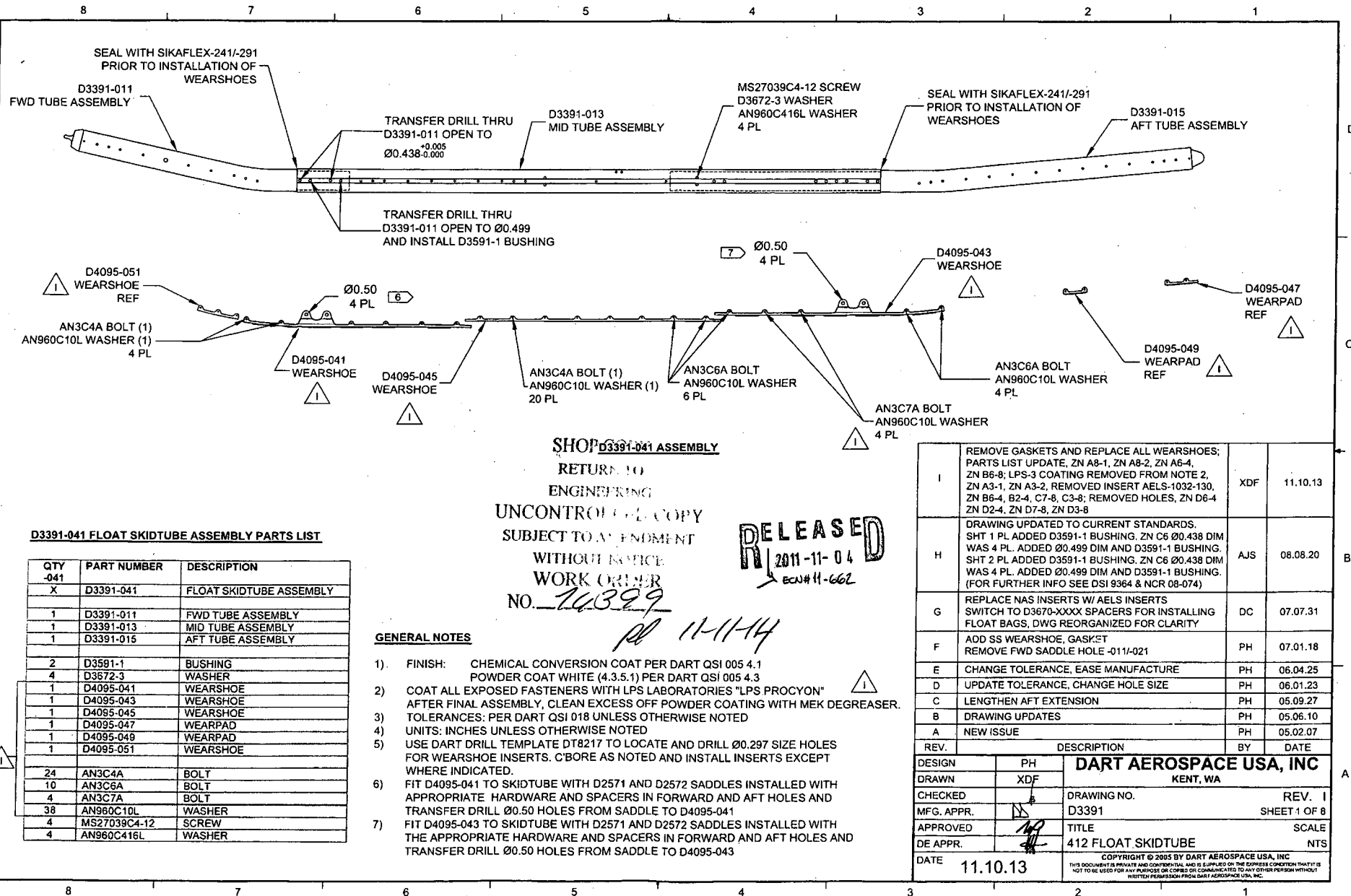
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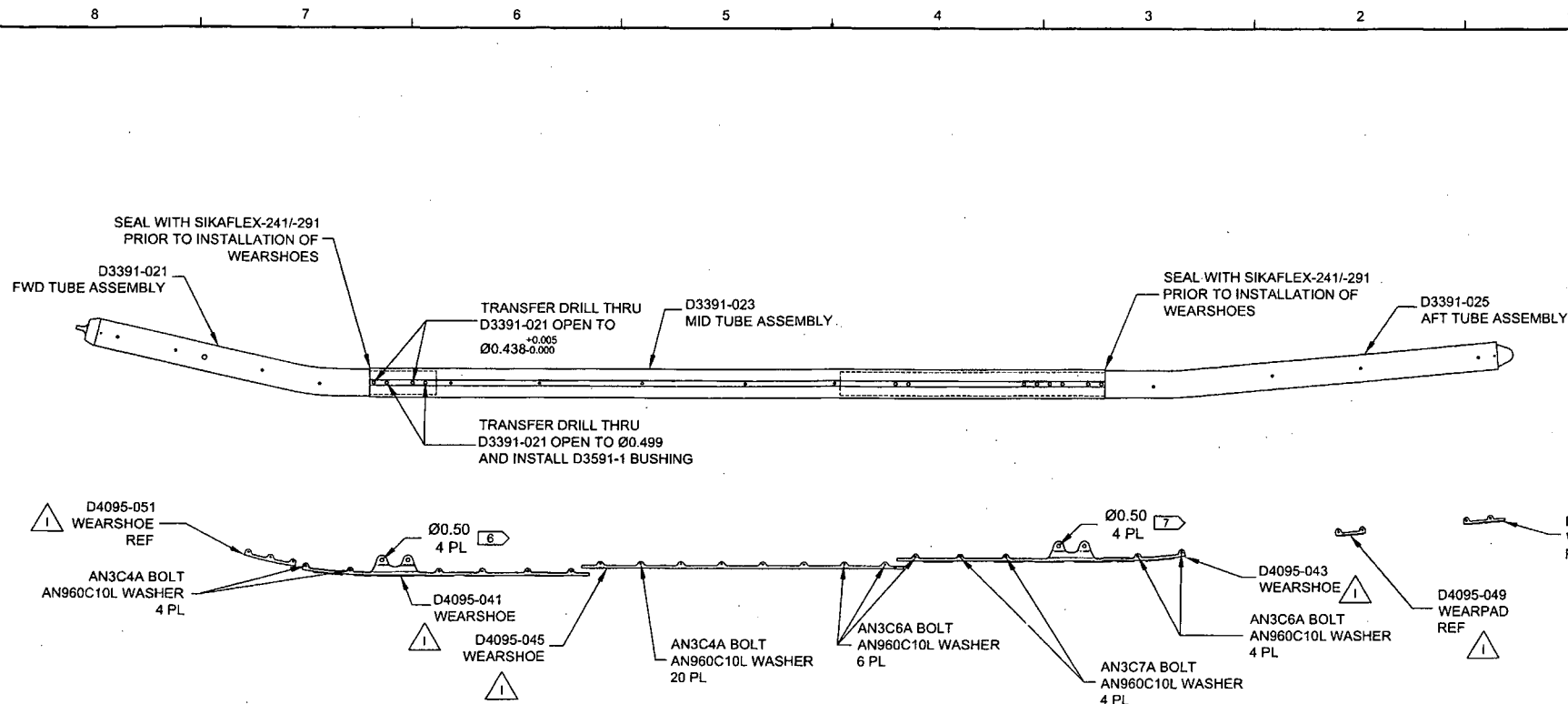
W/O:		WORK ORDER CHANGES					
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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2011-11-04

14389

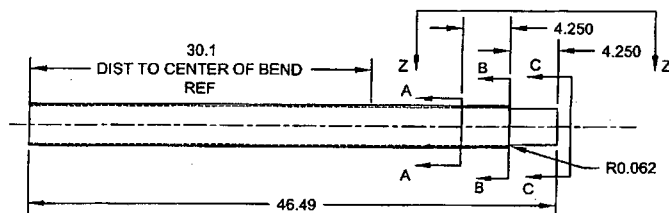
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

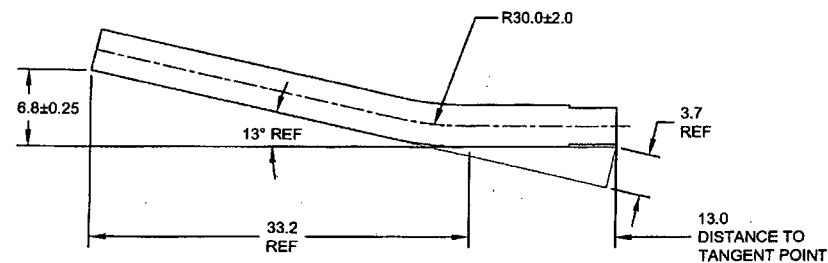
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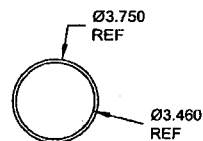
NOTE: Date & initial all entries



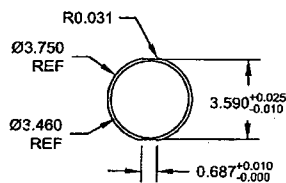
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



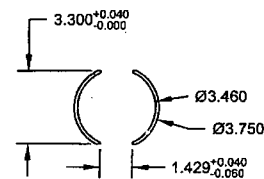
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



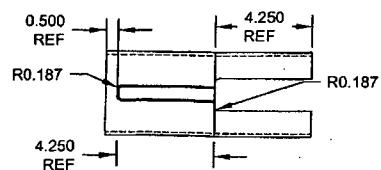
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

16399

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XOF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

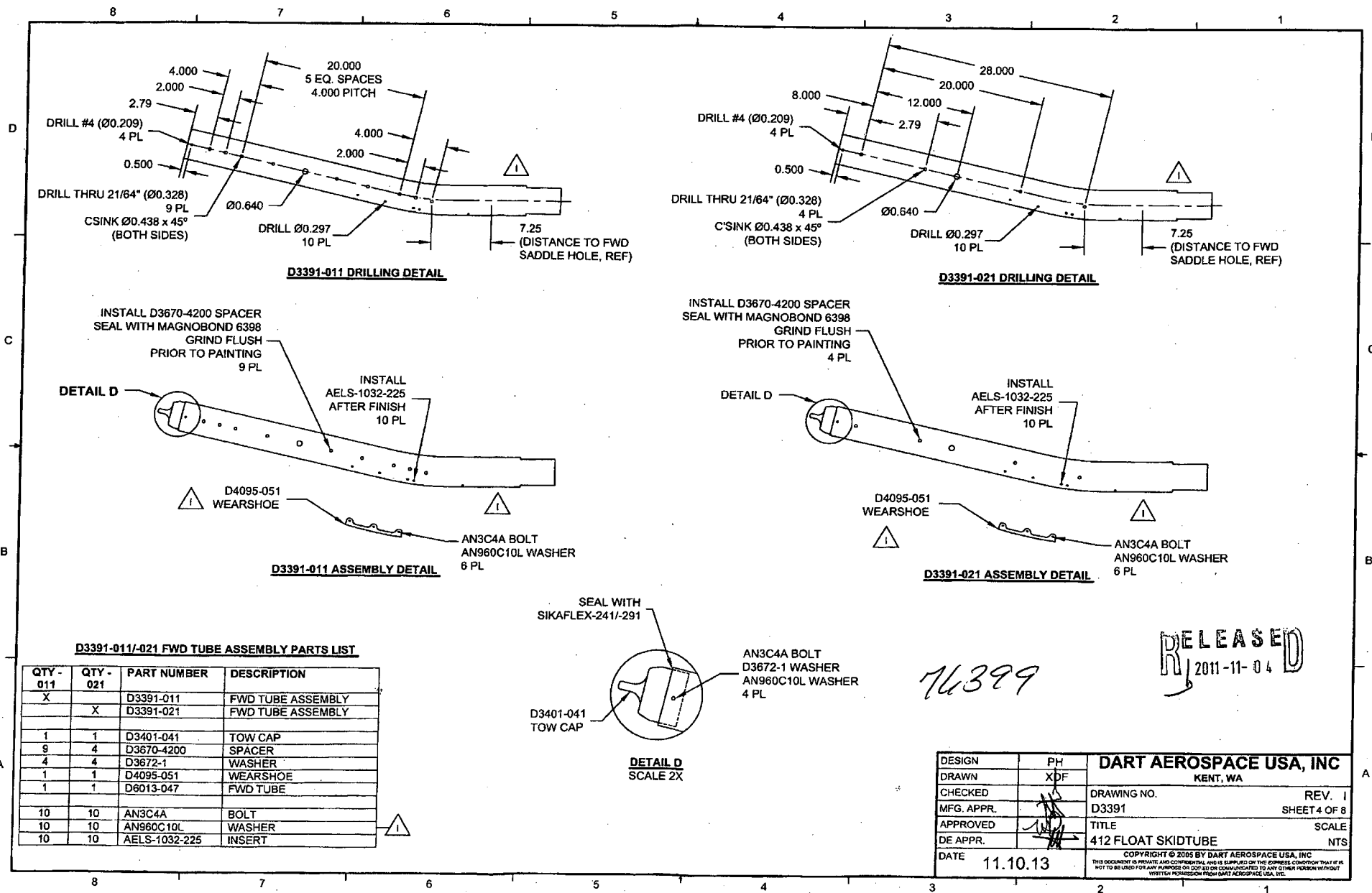
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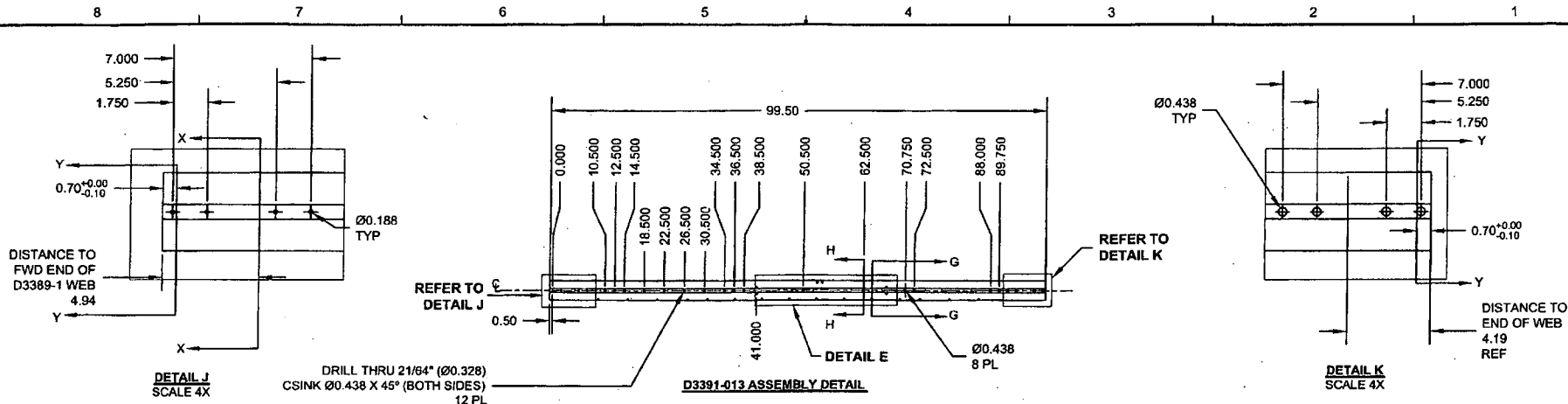
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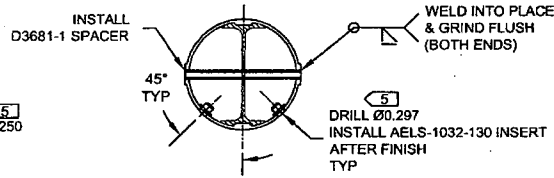
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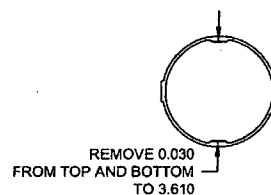
NOTE: Date & initial all entries



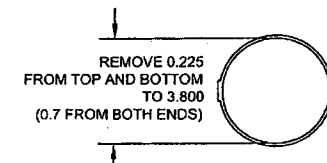
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



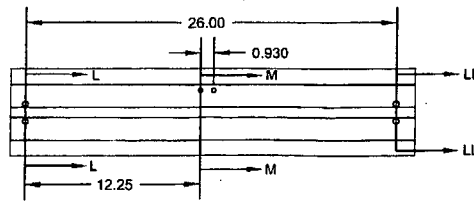
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

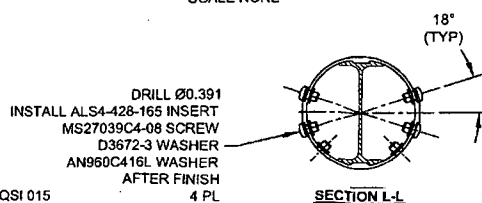
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

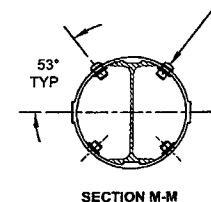
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



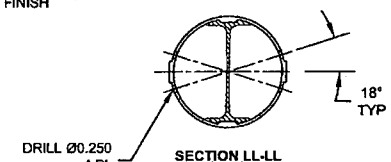
DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

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11/2011-11-04

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MFG. APPR.		D3391	SHEET 5 OF 8
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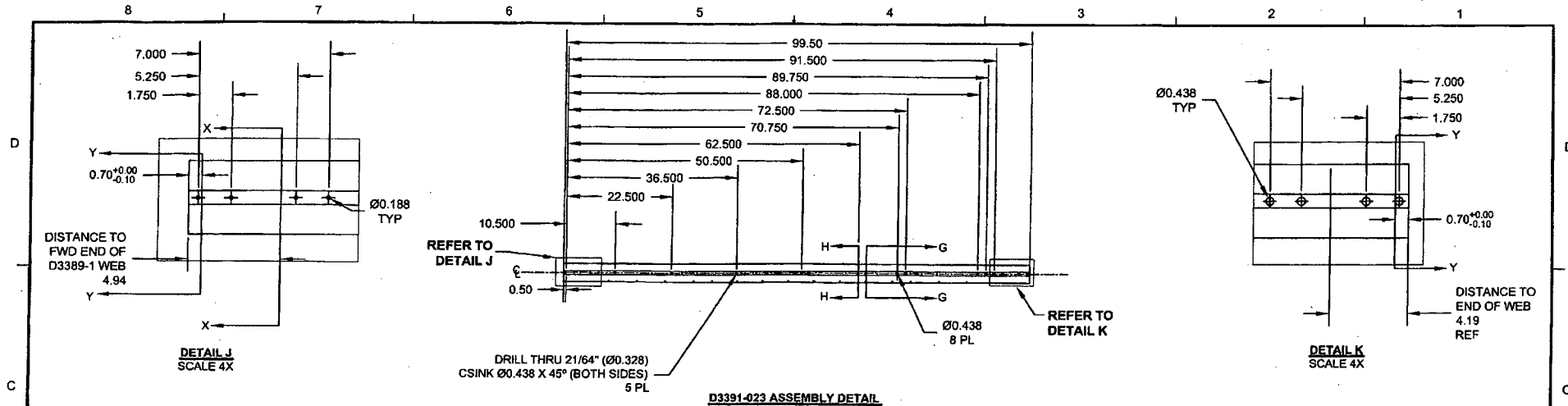
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

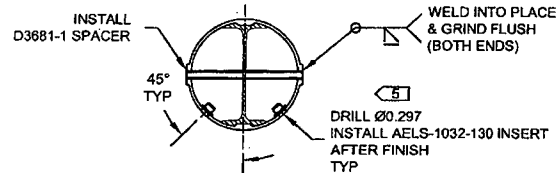
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

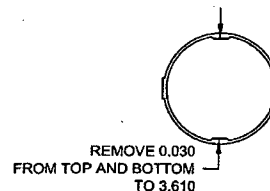
NOTE: Date & initial all entries



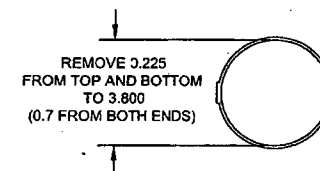
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

96399

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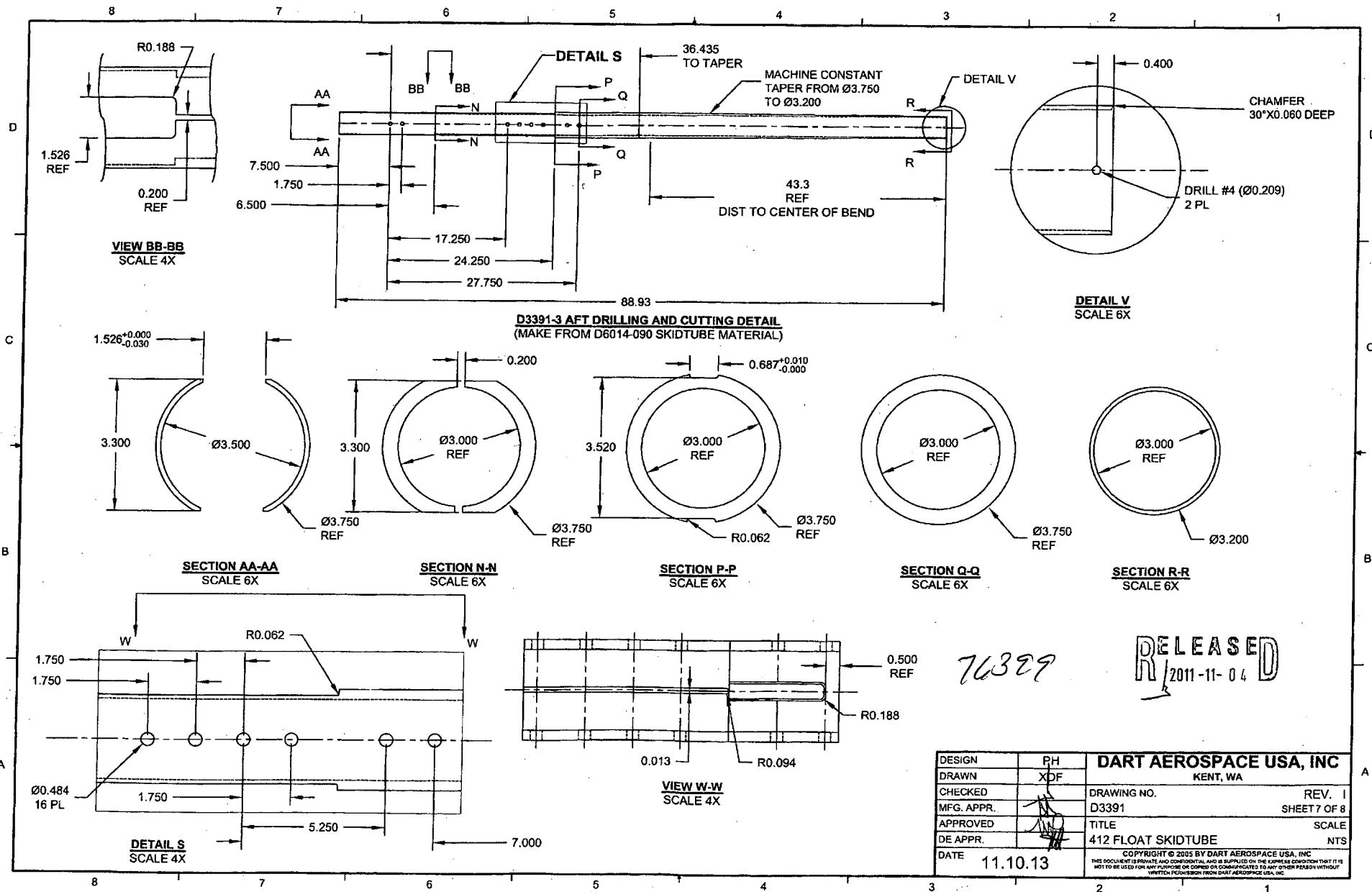
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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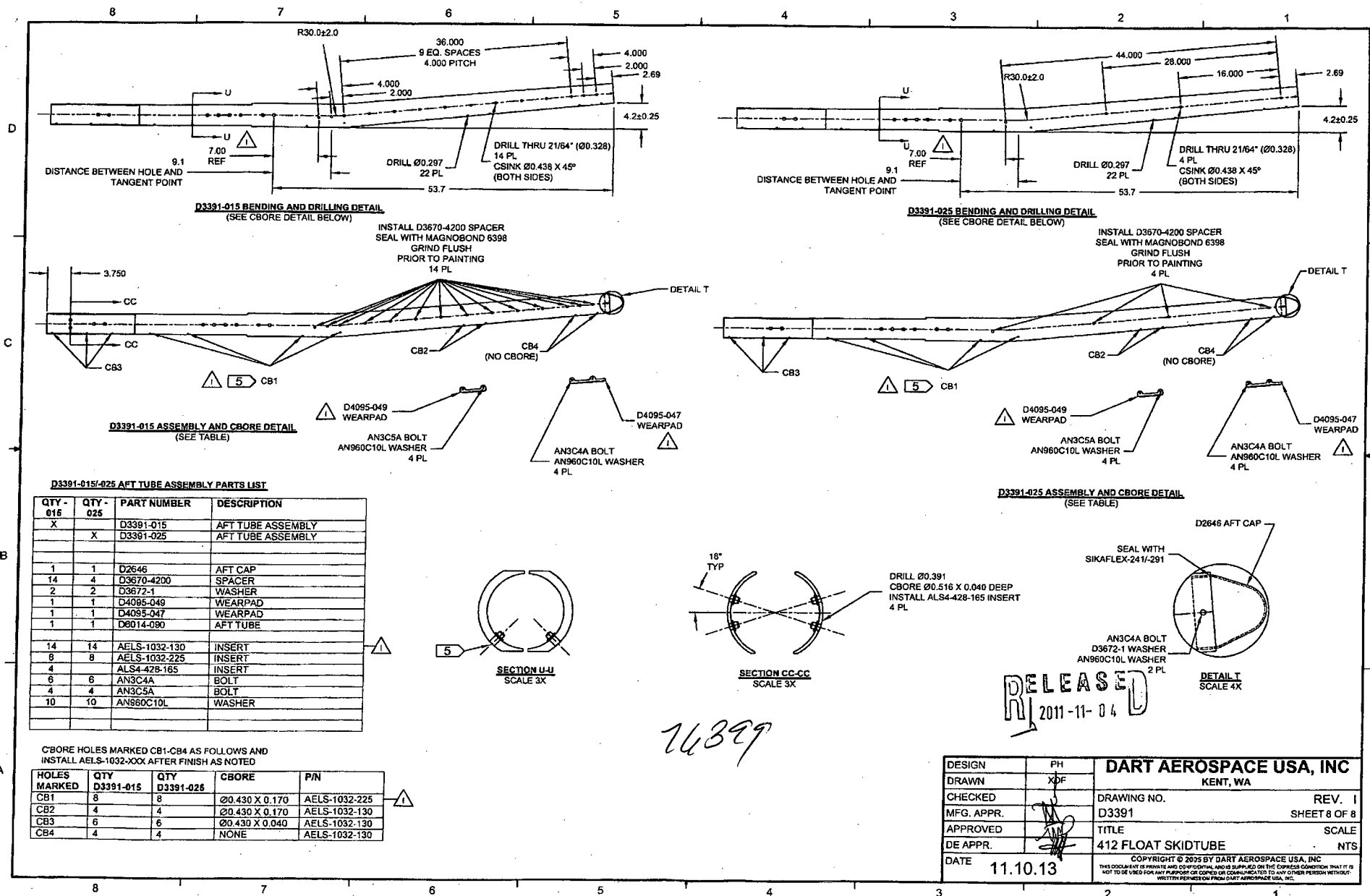
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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NOTE: Date & initial all entries